

SHIP ROBBY

## Work Order ID 65840



Page 1

Wednesday, January 26, 2011 11:33:49 AM

Item ID: D412-698-019

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearing Overhaul

Start Date: 1/26/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*R*

Date:

*11-01-24*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100

0.00



DOCUMENT CONTROL

*R*

DC

Memo

0.00

Document Control

Photocopy bluefile &amp; type labels per PPPD412-698-019

CHG001

*Sub 2103*

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

*11/2/3* *(12)* *(1)*

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

*Sub 2103**(14)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 65840**

Wednesday, January 26, 2011 11:33:49 AM

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Item ID: D412-698-019

Accept

Revision ID:

Item Name: Bearing Overhaul



Start Date: 1/26/2011 Start Qty: 1.00

Required Date: 2/7/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Packaging	0.00				11/13	sf		(12)
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-019 □ Location: 3/15 □ PPP Rev: A								
140  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

MF  
11-02-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Picklist Print

Wednesday, January 26, 2011 11:33:54 AM

Page 1

**Work Order ID:** 65840

**Parent Item:** D412-698-019

**Parent Item Name:** Bearing Overhaul

**Start Date:** 1/26/2011

**Required Date:** 2/7/2011

**Start Qty: 1.00**

**Required Qty: 1.00**

**Comments:** IPP Rev:B 05-10-12 Pick List Revised KJ/JLM  
IPP Rev:C 08-01-28 change to rev D ECN 1104 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-21 Bolt		Manufactured	No				Each	3.0000		7.5x B65659		11/2/38	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST235				3					
				57376				1					
				65096				2					
D3121-241 Bearing Assembly		Manufactured	No				Each	22.0000		2 11/2/38			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST235B				22					
				65178				22					
D3137-3 Guide		Manufactured	No				Each	23.0000		5 11/2/38			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST235B				23					
				63873				3					
				65642				20					
D3137-5 Washer		Manufactured	No				Each	5.0000		1 11/2/38			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST235B				5					
				65365				5					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 2

Wednesday, January 26, 2011 11:33:55 AM

Work Order ID: 65840

Parent Item: D412-698-019

Parent Item Name: Bearing Overhaul

Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 1.00

Required Qty: 1.00

D3183-045 Manufactured No

Each 25.0000



Bearing Assembly



2  
11/2/2011

Location

Loc Qty

Loc Code

ST236

25

63989

25

MS24694-S101 Purchased No

Each 40.0000



Screw



2  
11/2/2011

12

Location

Loc Qty

Loc Code

ST290A

40

110363

40

1

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



### 6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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Revision: E  
Date: 08.05.01

